

Date: Monday, 2/5/2007 8:09:11 AM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW
Job Number : 30619 ✓	
Estimate Number : 12701	
P.O. Number : N/A	Part Number : D119647011 ✓
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D3034 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 2/15/2007 Qty: 4 Um: Each
Checked & Approved By : <u>07.02.05</u>	
Comment : Est Rev:A New Issue 07-02-02 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPP D119-647-011

CHG 002 ✓

07.03.05 (4)

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.2284 sf(s)/Unit Total : 16.9134 sf(s)

UHMW 1" Black 28.75" X19.50"

Batch: M103315 = 3 pieces

cut 2 blacks per

M103375 = 5 pieces

07/04/10 8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA148 Rev: AA & Dwg D3034 Rev: A1

2-Deburr per dwg D3034

07/04/10 8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/04/10 8

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07-03-11 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/5/2007 8:09:11 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 30619

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182

Heat Shrink



Comment: Qty.: 0.4809 f(s)/Unit Total : 1.9236 f(s)

Heat Shrink

Batch: B26009 ✓

6x 5.5" *[Signature]*

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Radius Block

Batch: B30875 ✓

9.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Batch: B30382 ✓

10.0

D2947

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Clamp

Batch: B30386 ✓

11.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: M04072 ✓

12.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Batch: M5519 ✓

7/1/16 SQ

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:09:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 30619

Part Number: D119647011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut

Batch: M103914 ✓

7/4/16 SQ

14.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U. 07/04/17

7/4/17 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-647-011

Location: B

PPP Rev: B

7/4/17 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)  
7/4/18

Job Completion



U. 07-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

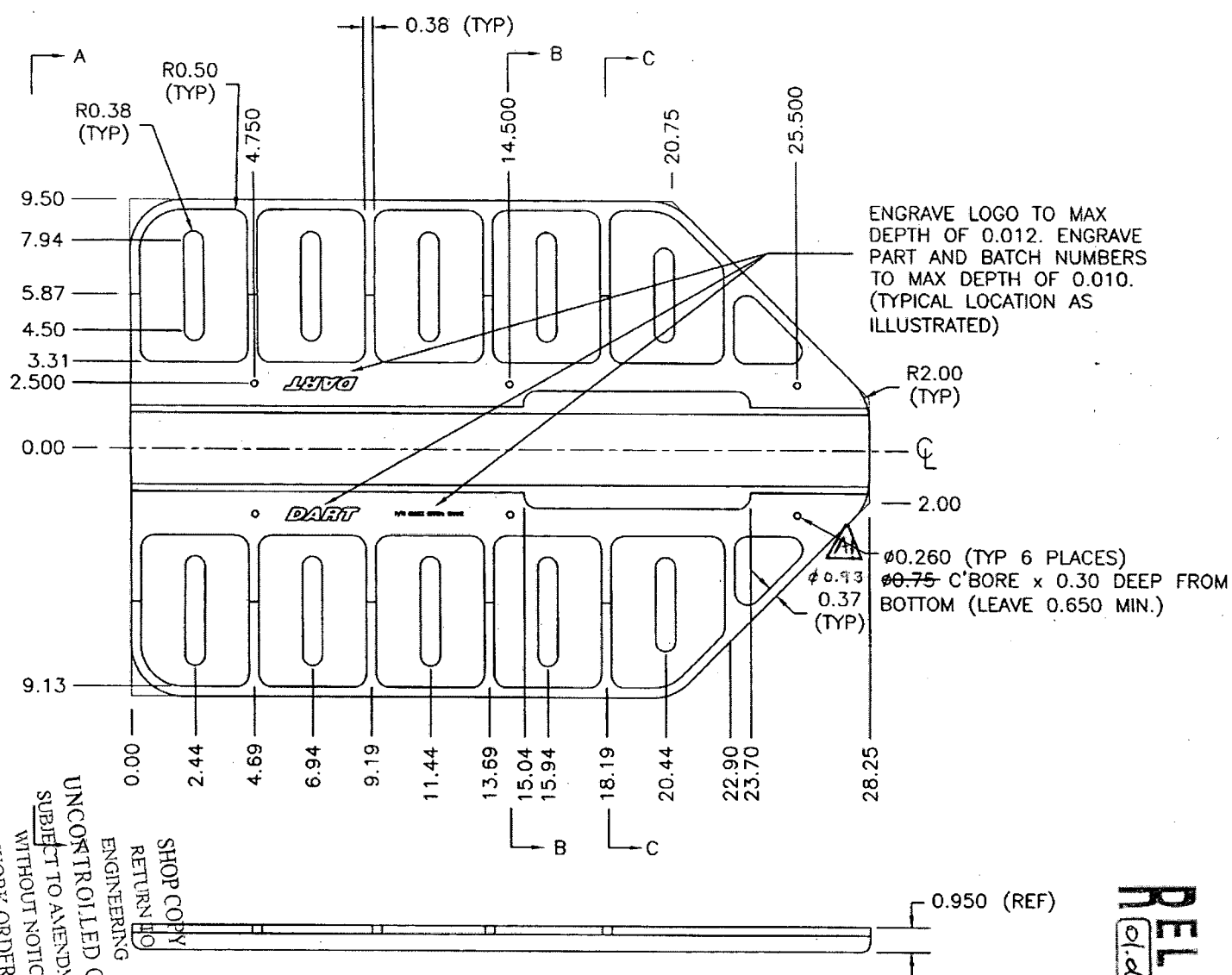
**NOTE:** Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	DRAWING NO.	REV. A
01.06.21	D3034	SHEET 1 OF 2
	TITLE	SCALE
	BEARPAW	1:6
A	01.06.21	NEW ISSUE

**RELEASED**  
01.06.26



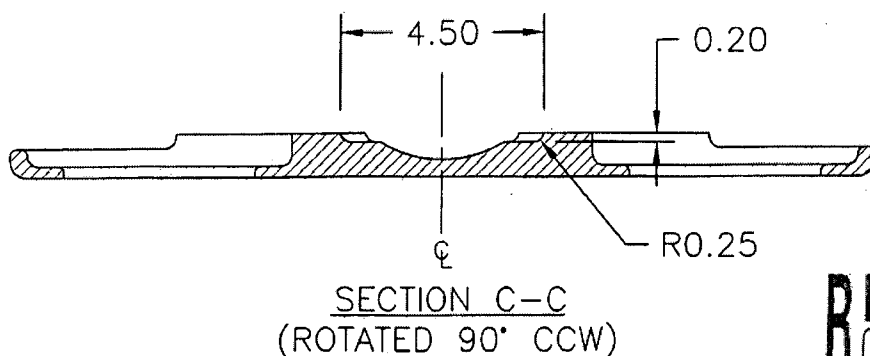
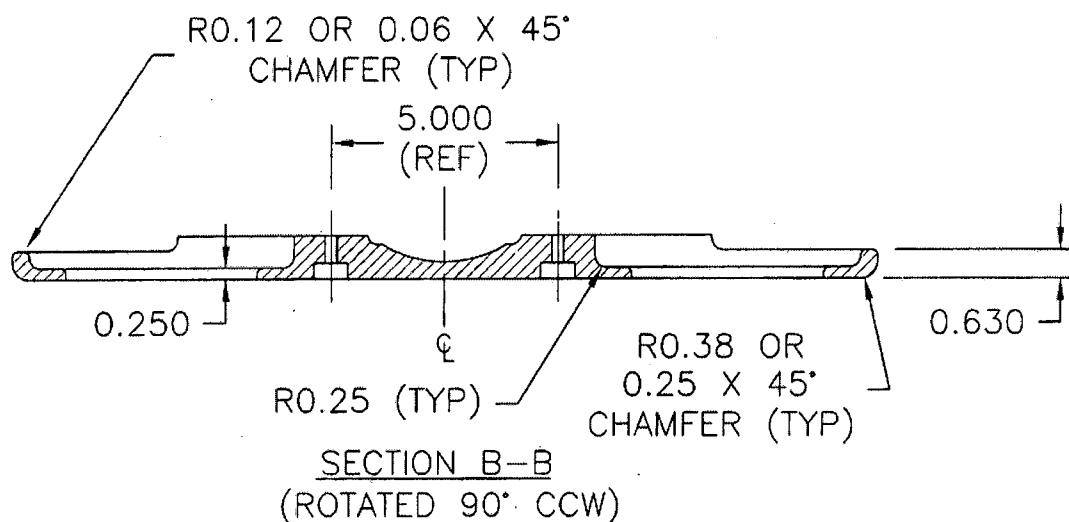
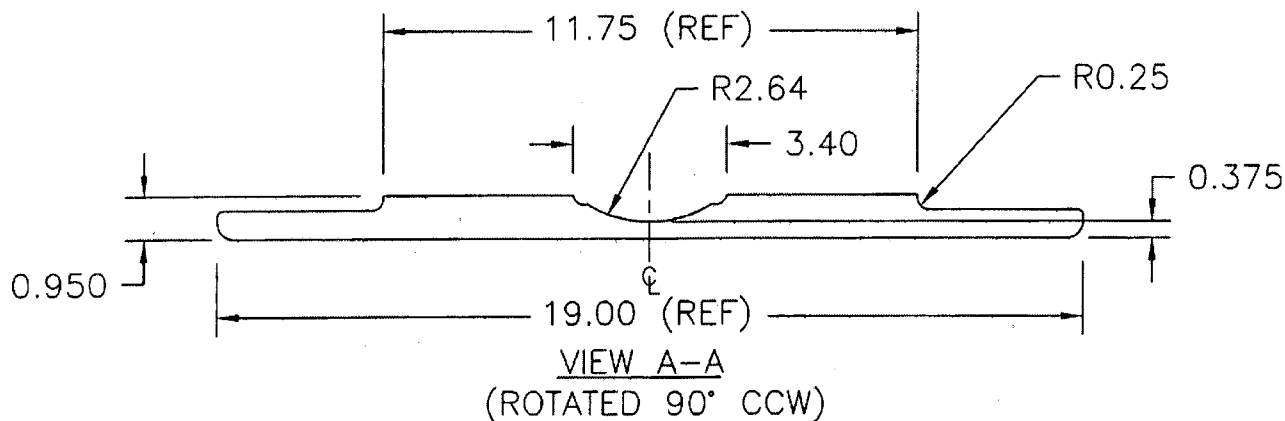
D3034-1  
BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)  
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
30613

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CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3034	REV. A SHEET 2 OF 2
DATE 01.06.21	TITLE BEARPAW		SCALE 1:4



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*a.d. 26*

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<b>D3034DART AEROSPACE LTD</b>		<b>Work Order:</b> 30619
<b>Description:</b> Bearpaw		<b>Part Number:</b> D3034-1
<b>Inspection Dwg:</b> D3034 <b>Rev:</b> A1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	11.75	+/-0.030	11.750	—			
B	3.40	+/-0.030	3.400	—			
C	19.00	+/-0.030	19.000	—			
D	0.375	+/-0.010	0.369	—			
E	0.950	+0.030/-0.010	0.962	—			
F	0.06 x 45°	+0.030/-0.010	0.057x45°	—			
G	0.25 x 45°	+/-0.030	0.244x45°	—			
H	R0.25	+/-0.030	R0.250	—			
I	0.630	+/-0.030	0.610	—			
J	0.250	+/-0.010	0.248	—			
K	4.50	+/-0.030	4.500	—			
L	0.20	+/-0.030	0.204	—			
M	Ø0.260	+0.005/-0.000	Ø0.260	—			
N	Ø0.93	+/-0.030	Ø0.927	—			
O	0.30	+0.030/-0.000	0.310	—			
P	28.25	+/-0.030	28.250	—			
Q	0.37	+/-0.030	0.386	—			
R	4.750	+/-0.030	4.750	—			
S	9.750	+/-0.010	9.750	—			
T	11.000	+/-0.010	11.000	—			
U	8.66	+/-0.030	8.660	—			
V	5.000	+/-0.010	5.000	—			

<b>Measured by:</b> <i>ms</i>	<b>Audited by:</b> <i>ms</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/10	<b>Date:</b> 07/04/10	<b>Date:</b>	N/A

Rev.	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D119-647-011	KJ/RF	